



Dart Aerospace Ltd.
1270 Aberdeen St
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RB DB3182-21
Job Sheet 200027



Part No: RB DB3182-21

Job Qty: 2 pcs *Q MLL*

Part Name: Quill Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/6/19

Job Tracking No:

Due Date: 9/30/19

Created By: Jennifer Renwick

Type: Stock

Description:

Note: DWG RB DB3182 Rev F IPP Rev. A 19.05.16 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	2 pcs	9/30/19	0.00	0.40	Small Fab - 1		MLL	
						Small Fab - 2			
						Small Fab - 3			
						Small Fab - 4			
						Small Fab - 5			
						Small Fab - 6			
						Small Fab - 7			
						Small Fab - 8			
120	QC 5	2 pcs	9/30/19	0.00	0.00	QC 5 - 10			
						QC 5 - 12			
						QC 5 - 17			
						QC 5 - 18			
						QC 5 - 19			
						QC 5 - 22			
						QC 5 - 24			
						QC 5 - 3			
						QC 5 - 43			
						QC 5 - 49			
						QC 5 - 51			
						QC 5 - 58			
						QC 5 - 68			
						QC 5 - 9			
						QC 5 - 50			
						QC 5 - 30			
						QC 5 - 40		DAS 81 9-89	OCT 04 2019
						QC 5 - 61			
						QC 5 - 81			



Container No: S219736

Part: RB DB3182-21
Job No: 200027
Serial No/Batch: S219736
Revision: F
Inspector:
Exp Date:
Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL : 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/04/19



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Container No: S219736



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Instructions:

Date: 10/04/19

Plex 9/6/19 8:32 AM Dart.Renwick.Jennifer

130 Packaging 3-1 - Stock - B4B 2 pcs

9/30/19

0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

Packaging 3 - 32 - B4B

Packaging 3 - 33 - B4B

Packaging 3 - 34 - B4B

Packaging 3 - 35 - B4B

Packaging 3 - 36 - B4B

M/L

140 QC 21 - SA

2 pcs

9/30/19

0.00 0.00

QC 21 - SA - 21

QC 21 - SA - 70

QC 21 - SA - 53

OCT 04 2019

21
9-89GA
076

Part Op 110 - 1-Assemble as per drawing. See note 8,9 and 10.

Descriptions: 120 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
9263K642	O-Ring	2 Ea (1 ea)	110-Small Fab - 1	5078377
98380A433	416 SS DOWEL PIN 3/32" DIA. x 3/16" LG.	18 Ea (3 ea)	110-Small Fab - 1	5183024
RB DB3182-1	Extension	6 Ea (1 ea)	110-Small Fab - 1	5214734
RB DB3182-3	Quill	6 Ea (1 ea)	110-Small Fab - 1	5190677

25x60

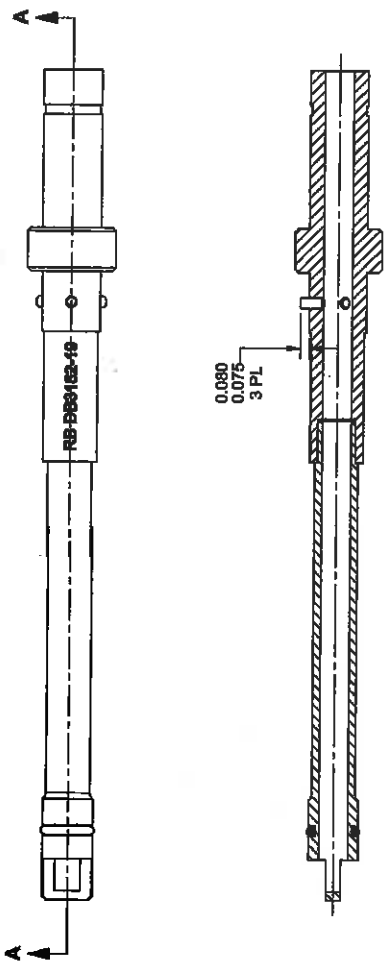
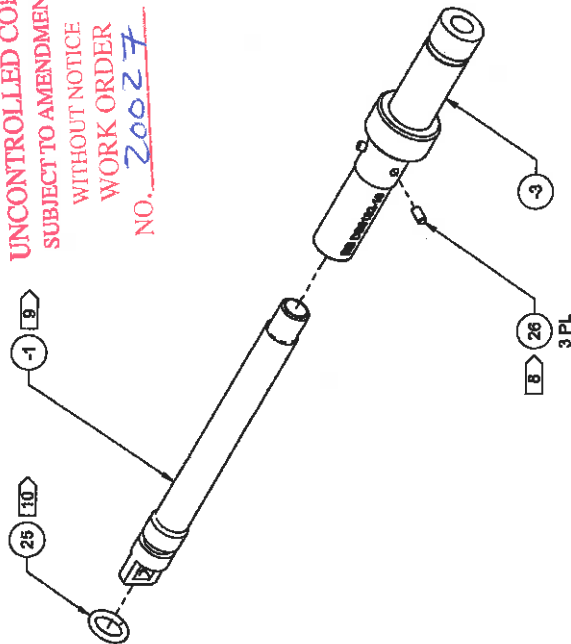
012261

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	9263K642	2	31	0
	98380A433	6	50	0
	RB DB3182-1	2	0	0
	RB DB3182-3	2	10	0
Part Specifications				
Specifications could not be found.				

Plex 9/6/19 8:32 AM Dart.Renwick.Jennifer

ITEM #	QTY	PART #	PART TITLE
-1	1	RB DB3182-1	EXTENSION
-3	1	RB DB3182-3	QUILL
25	1	McMaster#9263K642 OR EQUIV.	VITON O-RING 7.8 mm ID. X 1.6 mm OD. X 1.9 mm WD.
26	3	McMaster#9838DA433 OR EQUIV.	418 SS DOWEL PIN 3/32" DIA. X 3/16" LG.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 20027



RB DB3182-21 QUILL ASSEMBLY

- NOTES:**
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$
X.XX = $\pm 0.01"$ / $\pm 0.5"$
X.XXX = $\pm 0.005"$ / $\pm 0.1"$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLY AS SHOWN
 - 8) APPLY RETAINING COMPOUND LOCITE 620 OR EQUIVALENT ON MATING SURFACES
 - 9) THEN PRESS FIT ITEM 26 WITH ITEM -3, AND REMOVE EXCESS
 - 10) APPLY RETAINING COMPOUND LOCITE 620 OR EQUIVALENT ON MATING SURFACES
 - 11) THEN PRESS FIT ITEM -1 WITH ITEM -3, AND REMOVE EXCESS
 - 12) APPLY MOLYKOTE 65 OR EQUIVALENT ON ITEM 25 THEN ASSEMBLY WITH ITEM -1, AND REMOVE EXCESS

DESIGN	DRAWN	CHECKED	MFG. APPR.	APPROVED	DATE	3/7/2019
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA TOOL PART # RB DB3182 TITLE MAIN TRANSMISSION DRAIN TOOL SCALE NTS REV. F SHEET 3 OF 8 Copyright © 2018 BY DART AEROSPACE LTD All Rights Reserved. No part of this document may be reproduced or transmitted in any form or by any means electronic or mechanical, including photocopying and recording, or by any information storage or retrieval system, without permission in writing from DART AEROSPACE LTD.						REV. F SHEET 3 OF 8 SCALE NTS